(12) INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(19) World Intellectual Property Organization
International Bureau

(43) International Publication Date
14 July 2005 (14.07.2005)

PCT

(10) International Publication Number
WO 2005/063448 A1

(51) International Patent Classification[7]: B25B 23/145

(21) International Application Number:
PCT/SE2004/002020

(22) International Filing Date:
27 December 2004 (27.12.2004)

(25) Filing Language: English

(26) Publication Language: English

(30) Priority Data:
0303555-7 29 December 2003 (29.12.2003) SE

(71) Applicant *(for all designated States except US)*: **ATLAS COPCO TOOLS AB** [SE/SE]; S-105 23 Stockholm (SE).

(72) Inventors; and

(75) Inventors/Applicants *(for US only)*: **FRIBERG, Christian, John, Robert** [SE/SE]; Fyrspannsv. 8, S-131 48 Nacka (SE). **SCHOEPS, Christian, Knut** [SE/SE]; Klotvägen 6, S-135 47 Tyresö (SE). **SJÖBLOM, Torbjörn, Rafael** [SE/SE]; Ymsenvägen 14, 6tr, S-120 38 Årsta (SE). **KARLBERG, Erland** [SE/SE]; Mjölnerbacken 41, S-174 48 Sundbyberg (SE).

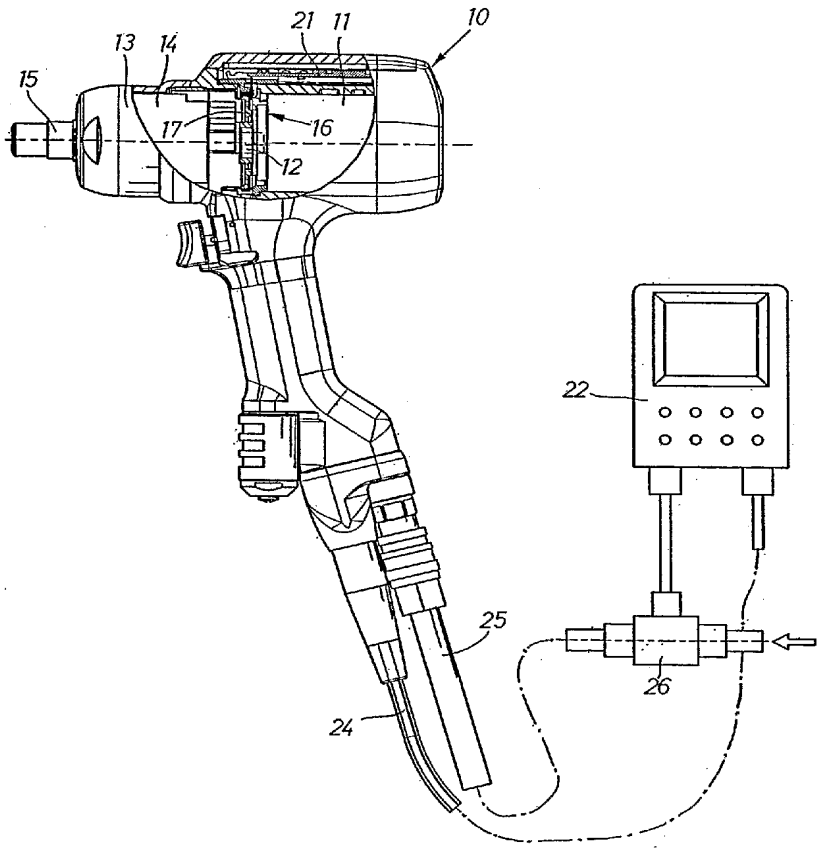
(74) Agent: **PANTZAR, Tord**; Atlas Copco Tools AB, S-105 23 Stockholm (SE).

(81) Designated States *(unless otherwise indicated, for every kind of national protection available)*: AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BW, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NA, NI, NO, NZ, OM, PG, PH, PL, PT, RO, RU, SC, SD, SE, SG, SK, SL, SY, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, YU, ZA, ZM, ZW.

(84) Designated States *(unless otherwise indicated, for every kind of regional protection available)*: ARIPO (BW, GH,

[Continued on next page]

(54) Title: METHOD FOR GOVERNING THE OPERATION OF A PNEUMATIC IMPULSE WRENCH AND A POWER SCREW JOINT TIGHTENING TOOL SYSTEM



(57) Abstract: A method and a power tool system for screw joint tightening by means of a pneumatic torque impulse power tool (10) controlled by a stationary programmable control unit (22) and via a torque magnitude and torque growth calculation based on signals delivered by an angle sensing device (16) on the impulse unit (13) of the power tool (10), wherein motive pressure air is supplied to the power tool via a flow regulating valve (26) which is successively adjustable between zero and a full power flow. The flow regulating valve (26) is controlled by the control unit (22) to deliver a reduced power air flow to the power tool (10) before and during the very first delivered impulse, then delivering a full power flow until a certain torque magnitude or a certain percentage of the target torque level is reached, whereafter the air supply flow is again reduced until the target torque level is reached, and when the target torque level is reached the air flow is shut off.

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GM, KE, LS, MW, MZ, NA, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European (AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HU, IE, IS, IT, LT, LU, MC, NL, PL, PT, RO, SE, SI, SK, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

Published:
— *with international search report*

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